



007990

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBE105-31702W23
Job Sheet 184994



Part No: RBE105-31702W23

Job Qty: 1 pcs

Part Name: Measuring Device



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/19/18

Job Tracking No:

Due Date: 12/26/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-31702W23 Rev.1 IPP Rev. A 18.10.18 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter	Supplier		
110	Small Fab - 1	1 pcs	12/26/18		0.00	1.00	Small Fab - 1			58 FEB 07 2019 9-89
							Small Fab - 2			
							Small Fab - 3			
							Small Fab - 4			
							Small Fab - 5			
							Small Fab - 6			
							Small Fab - 7			
120	QC 5	1 pcs	12/26/18		0.00	0.00	QC 5 - 10			9-89 12/26/18
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 38			
							QC 5 - 42			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			
							QC 5 - 30			
130	Packaging 3-1 - Stock - B4B	1 pcs	12/26/18		0.00	0.00	Packaging 3 - 1 - B4B			12/26/18
							Packaging 3 - 2 - B4B			
							Packaging 3 - 3 - B4B			
							Packaging 3 - 4 - B4B			
							Packaging 3 - 5 - B4B			
							Packaging 3 - 6 - B4B			



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CANADA
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Container No: S151742



Part: RBE105-31702W23

Job No: 184994

Serial No/Batch: S151742

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 02/07/19

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	DAS
				Packaging 3 - 10 - B4B	28
				Packaging 3 - 11 - B4B	9-89
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	1 pcs	12/26/18	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
Part Op 110 - (Small Fab) 1-Assemble as per DWG. Descriptions: 120 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
RBE105-31702W23-1	Locating Bolt	1 pcs (1 ea)	110-Small Fab - 1	5140907	
RBE105-31702W23-15	Adjustable Sleeve	1 Ea (1 ea)	110-Small Fab - 1	5143637	
RBE105-31702W23-3	Knurled Nut	1 pcs (1 ea)	110-Small Fab - 1	5142600	
RBE105-31702W23-5	Measuring Washer	2 pcs (2 ea)	110-Small Fab - 1	5137226	
RBE105-31702W23-7	Measuring Flange RH Assembly	1 pcs (1 ea)	110-Small Fab - 1	5147431	
RBE105-31702W23-9	Measuring Flange LH Assembly	1 pcs (1 ea)	110-Small Fab - 1	5147426	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Small Fab - 1	RBE105-31702W23-1	1	3	0	
	RBE105-31702W23-15	1	8	0	
	RBE105-31702W23-3	1	5	0	
	RBE105-31702W23-5	2	10	0	
	RBE105-31702W23-7	1	0	0	
	RBE105-31702W23-9	1	0	0	
Part Specifications					
Specifications could not be found.					



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Job Sheet 184994



10009
Dec-21

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Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/26/18	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	1 pcs		12/26/18	0.00	1.00	Small Fab-3		
120	QC	1 pcs		12/26/18	0.00	0.00	QC5		
130	Packaging	1 pcs		12/26/18	0.00	0.00	Packaging3-1		
140	QC21-FG	1 Ea		12/26/18	0.00	0.00	QC21		

Part Op
Descriptions: 110 - 1-Assemble as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE105-31702W23-1	Locating Bolt	1 Ea (1 ea)	90-Start up Operation	
RBE105-31702W23-15	Adjustable Sleeve	1 Ea (1 ea)	110-Small Fab	
RBE105-31702W23-3	Knurled Nut	1 Ea (1 ea)	110-Small Fab	
RBE105-31702W23-5	Measuring Washer	2 Ea (2 ea)	110-Small Fab	
RBE105-31702W23-7	Measuring Flange RH Assembly	1 Ea (1 ea)	110-Small Fab	
RBE105-31702W23-9	Measuring Flange LH Assembly	1 Ea (1 ea)	110-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBE105-31702W23-1	1	0	0
110-Small Fab	RBE105-31702W23-15	1	0	0
	RBE105-31702W23-3	1	0	0
	RBE105-31702W23-5	2	0	0
	RBE105-31702W23-7	1	0	0
	RBE105-31702W23-9	1	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

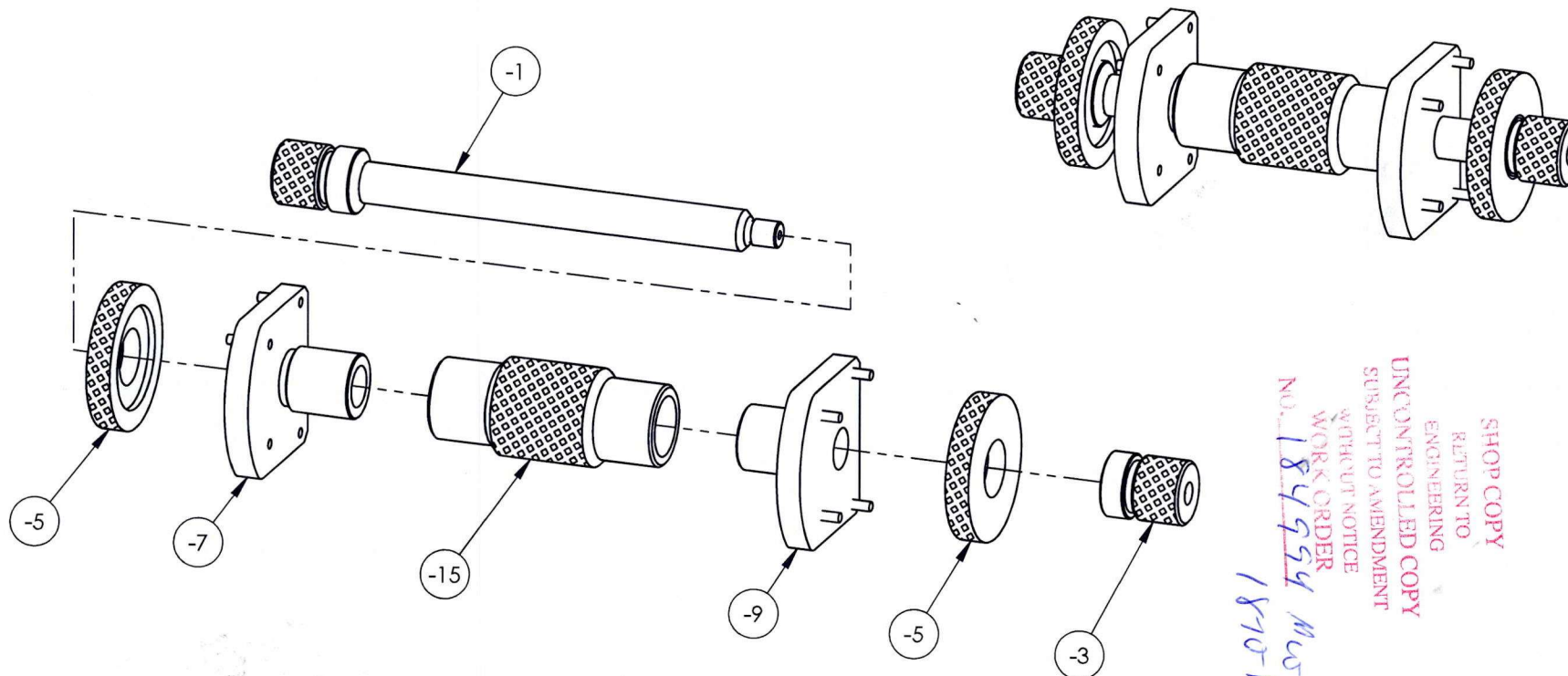
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
1		RELEASED FOR PRODUCTION.			8/31/2016	DPD JAG



SHOP COPY
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SUBJECT TO AMENDMENT
NO. 184994 M05
187015
WORK ORDER
NOTICE

NOTE:
REF. EUROCOPTER T/N: 105-31702W23.

DART AEROSPACE																	
MEASURING DEVICE																	
DWG NO.	REV 1																
RBE105-31702W23																	
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>HEAT TREAT</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>FINISH</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td>SPEC</td> <td>.XX ± .01 ANGLES ± 5°</td> </tr> <tr> <td></td> <td>.X ± .1 SURFACES = 125/</td> </tr> <tr> <td colspan="2">1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td colspan="2">2. DIMENSIONAL LIMITS APPLY AFTER PLATING</td> </tr> <tr> <td colspan="2">3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED	HEAT TREAT	DIMENSIONS ARE IN INCHES	FINISH	.XXX ± .005 FRACTIONS ± 1/8	SPEC	.XX ± .01 ANGLES ± 5°		.X ± .1 SURFACES = 125/	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		2. DIMENSIONAL LIMITS APPLY AFTER PLATING		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
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DRAWN BY:	DUERFELDT																
CHECKED:	CLOUGH																
OPPS APPR:	ANDERSON																
QA APPR:	LINDSAY																
APPROVED:	GILBERT																
USED ON MODEL EC145																	
SCALE	DATE																
1:2	1/18/2016																
SHEET 1 OF 9																	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	LOCATING BOLT	BRASS		2
			-3	1	KNURLED NUT	BRASS		3
			-5	2	MEASURING WASHER	4140/4142		4
	X		-7	1	MEASURING FLANGE RH ASSEMBLY			5
X			-9	1	MEASURING FLANGE LH ASSEMBLY			6
	1		-11		MEASURING FLANGE PLATE RH	4140/4142		7
	1		-13		MEASURING FLANGE PLATE LH	4140/4142		8
			-15	1	ADJUSTABLE SLEEVE	BRASS		9
4	4	B/O	-17		DOWEL PIN	STEEL	M3 X 12mm (MCMaster-CARR #91595A112)	5,6
ASSY -9	ASSY -7							